

(19)



Europäisches Patentamt
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Office européen des brevets



(11) Publication number:

0 459 397 A3

(12)

EUROPEAN PATENT APPLICATION(21) Application number: **91108691.6**(51) Int. Cl.⁵: **H01L 21/76, H01L 21/308**(22) Date of filing: **28.05.91**

(30) Priority: **28.05.90 JP 135374/90**
28.05.90 JP 135375/90

(43) Date of publication of application:
04.12.91 Bulletin 91/49

(84) Designated Contracting States:
DE FR GB

(88) Date of deferred publication of the search report:
02.11.94 Bulletin 94/44

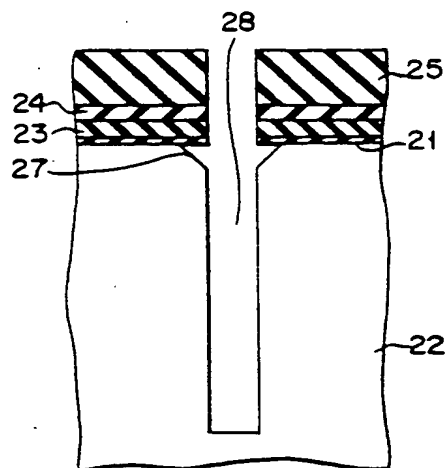
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(54) **Semiconductor device having a trench for device isolation and method of fabricating the same.**

(57) A device-isolating trench (28) having a taper at its upper portion is formed in a silicon semiconductor substrate (22). Then, a silicon oxide film (32) is formed on the inner wall of the trench (28) and the surface of the semiconductor substrate (22) near the trench (28) by an oxidizing method, and polycrystalline silicon (33) is buried in the trench (28).

**F I G. 2 C****EP 0 459 397 A3**



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EUROPEAN SEARCH REPORT

Application Number
EP 91 10 8691

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.5)
X	JOURNAL OF THE ELECTROCHEMICAL SOCIETY, vol.135, no.3, March 1988, MANCHESTER, NEW HAMPSHIRE US pages 726 - 730 Y. TAMAKI ET AL. 'EVALUATION OF DISLOCATION GENERATION IN U-GROOVE ISOLATION.' * the whole document *	1	H01L21/76 H01L21/308
X	IEDM -DECEMBER 13-14-15,1982, 1982, NEW-YORK pages 62 - 65 A. HAYASAKA ET AL. 'U-GROOVE ISOLATION TECHNIQUE FOR HIGH SPEED BIPOLAR VLSI'S' * the whole document *	1,2	
A	* figure 4 *	15	
X	JOURNAL OF THE ELECTROCHEMICAL SOCIETY, vol.134, no.2, February 1987, MANCHESTER, NEW HAMPSHIRE US pages 481 - 490 L. O. WILSON 'OXIDATION OF CURVED SILICON SURFACES' * page 481, left column, paragraph 1 - page 482, left column, paragraph 2; figures 2-9,A-1-B4 *	13,14	TECHNICAL FIELDS SEARCHED (Int.Cl.5) H01L
A	JAPANESE JOURNAL OF APPLIED PHYSICS, SUPPLEMENTS 18TH CONFERENCE ON SOLID STATE DEVICES AUGUST 20-22 1986, 1986, TOKYO JA pages 303 - 306 K. IMAI ET AL. 'DECREASE IN TRENCHED SURFACE OXIDE LEAKAGE CURRENTS BY ROUNDING OFF OXIDATION' * the whole document *	13,14	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 22 June 1994	Examiner VANCRAEYNST, F
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	



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EP 91108691.6

CLAIMS INCURRING FEES

The present European patent application comprised at the time of filing more than ten claims.

- ☐ All claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims and for those claims for which claims fees have been paid.
- namely claims:
- ☐ No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims.

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions.

namely:

See Sheet 3.

- ☐ All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid.
- namely claims:
- ☒ None of the further search fees has been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims.

namely claims: 1-2, 13-14



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EP 91108691.6 -8

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions, namely:

Claims 1-2, 13-15: Method for forming a trench isolation region provided with an oxide layer and filling said trench with polysilicon. Semiconductor device with trench isolation with a radius of a defined curvature.

Claims 3-12: Method of forming different type of trenches.